

Work Order ID 56448

February 24, 2010 8:03:01 AM



Page 1

Item ID: D412-630-032

Accept



Setup Start



Revision ID:

Item Name: Pilot/Co-Pilot Step, RH (Folding)

Stop



Start Date: 24/02/2010 Start Qty: 1.00

Required Date: 03/03/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference: Return 2009 / RA109003

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date: 1002.24

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-630

Rev M

100



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

Original B41778 @ CHG002
Part is in good condition.

0.00

5/26/24

kg fa cl 10/03/22

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1M7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D412-630-032	CHG	CHG002		
DESC.	Folding Step, RH	STC	SH96-69		
LOT	B41778	STC	SR00598NY		
MODEL	Bell 205/212/214/412	STC	SR00595/7NY		
MADE IN CANADA				D2729-1	

110



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

0.00

Memo

Clean & touch up step with Imron White per QSI005.

Clean & re-wing walk as necessary per drawing & QSI005

0.00

DR 10-3-17 @

120



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

all 10-3-17 X1 D

1911

1912

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Work Order ID 56448

February 24, 2010 8:03:01 AM



Page 2

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Reference: Return 2009 / RA109003

Cust Item ID:

Customer:



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Memo

-Remove lockwire.
-Pick new:
2x AN4CH3
2x D3443-9
-Adjust tension to 11 lbs per drawing.
-Install new lockwire.

0.00

0.00

10/03/18 ①

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/6/03/15

X1
RH

150



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

-Pick new kit
-New paperwork & labels are required at CHG002 (not 3).

5/6/03/24

10-3-22 sl

1911

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Work Order ID 56448

February 24, 2010 8:03:01 AM



Page 3

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Reference: Return 2009 / RA109003

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

5/06/24

Memo

Check off all that is not applicable.

0.00

④

170



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

NVC

0.00

2/10/24

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24

C21013124

Sample 100%



100%

Sample 100%



100%

Sample 100%



100%

Sample 100%

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Picklist Print

February 24, 2010 8:18:03 AM

Page 1 / 14

Work Order ID: 56448

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Date: 24/02/2010

Required Date: 03/03/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route	Unit of Each	Qty on	Remaining	Qty	Date	Status
AN310-4								54.0000	2.0000			
NUT												

XL

10-3-24 SP

AN310-4
 NUT

Purchased No

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	54	
	112969	9	
	113845	45	

Each 54.0000 1.0000

Barcode

N/A

u

AN310-5
 NUT

Purchased No

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	54	
	112969	9	
	113845	45	

Each 50.0000 2.0000

Barcode

10-3-24 SP

SP

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	50	
	113845	50	

u

100
100
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8

Picklist Print

February 24, 2010 8:03:01 AM

Page 2 / 14

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Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD

Start Date: 24/02/2010

Required Date: 03/03/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ AN310-7	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route	Unit of Each	Qty on 23.0000	Remaining 1.0000	Qty	Date	Status
NUT												

Warehouse

Location

Main Warehouse

ST

103286

111916

Loc Qty

Loc Code

23

3

20

Each

465.0000

3.0000

AN3C5A

Bolt

Purchased

No

Warehouse

Location

Main Warehouse

ST

111424

111707

112314

113121

113149

Loc Qty

Loc Code

465

8

69

1

125

262

M114056 10-3-24 SP

February 24, 2010 8:03:01 AM

Shop Packet Print

Page 2

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Picklist Print

February 24, 2010 8:03:01 AM

Page 3 / 14

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Start Date: 24/02/2010

Required Date: 03/03/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN44-C12		Purchased	No				Each	18.0000	1.0000			
eyebolt												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	18	
111888	18	

AN4C14



BOLT

Purchased No

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	27	
110552	7	
113899	20	

AN4C15



BOLT

Purchased No

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	32	
113618	12	
113908	20	

February 24, 2010 8:03:01 AM

Shop Packet Print

Page 3

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Picklist Print

February 24, 2010 8:03:01 AM

Page 4 / 14

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Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Date: 24/02/2010

Required Date: 03/03/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ AN4CH3	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route	Unit of Each	Qty on 11.0000	Remaining 2.0000	Qty	Date	Status
SS Bolt												
Warehouse Location Loc Qty Loc Code												
Main Warehouse												
ST												
111978												
11												
11												
Each												
38.0000												
1.0000												
10-3-24												
12												
Warehouse Location Loc Qty Loc Code												
Main Warehouse												
ST												
111279												
113422												
Main Warehouse												
ST337												
113950												
12												

February 24, 2010 8:03:01 AM

Shop Packet Print

Page 4

1954

1955

1. The first part of the report is a general introduction to the subject of the study. It discusses the importance of the problem and the objectives of the research. The second part is a literature review, which summarizes the work of other researchers in the field. The third part is a description of the methods used in the study. The fourth part is a presentation of the results of the study. The fifth part is a discussion of the results and their implications. The sixth part is a conclusion, which summarizes the main findings of the study.

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February 24, 2010 8:03:01 AM

Page 5 / 14

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Start Date: 24/02/2010

Required Date: 03/03/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN5C15		Purchased	No				Each	17.0000	1.0000			
BOLT												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	17	
	10121	2	
	110552	15	

AN960C10 JAS114900363R



WASHER

AN960C516



WASHER

Purchased No

Purchased No

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	208	
	102842	108	
	112532	100	

10-3-24

11/3/22

1.0000

10/3/23

11/02/22

February 24, 2010 8:03:01 AM

Shop Packet Print

Page 5

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Picklist Print

February 24, 2010 8:03:01 AM

Page 6

14

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3443-041		Manufactured	No				Each	5.0000	1.0000			
Strut Weldment Assembly												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
st196a	5	
55810	5	

D3443-043		Manufactured	No				Each	4.0000	1.0000			
Strut Weldment Assembly												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST198A	4	
55611	4	

February 24, 2010 8:03:01 AM

Shop Packet Print

Page 6

Picklist Print

February 24, 2010 8:03:01 AM

Page 7/14

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IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3443-9		Manufactured	No				Each	20.0000	2.0000			
Pin												

4510/03/18

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	2	
	53502	2	
Main Warehouse	ST56	18	
	55812	6	
	56298	12	

D3454-1



Bushing

Manufactured No

Each 17.0000 1.0000



10-3-22 SP

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	17	
	44588	2	
	53745	15	

1

Picklist Print

February 24, 2010 8:03:01 AM

Page 8

14

Work Order ID: 56448



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IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3454-3		Manufactured	No				Each	12.0000	2.0000			



Bushing



10-3-22 SP

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	12	
	48125	12	

D3454-5



Bushing

Manufactured No

42.0000 2.0000



2

10-3-20 SP

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	2	
	53697	2	
Main Warehouse	ST58	40	
	56046	40	

~~2~~

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Picklist Print

February 24, 2010 8:03:01 AM

Page 9 / 14

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3454-7		Manufactured	No				Each	32.0000	2.0000			
Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

2

46132

2

Main Warehouse

ST58

30

55608

30

Each

47.0000

4.0000

D3455-1



Spacer

Manufactured No

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

46138

3

Main Warehouse

ST58

44

55606

4

55807

40

February 24, 2010 8:03:01 AM

Shop Packet Print

Page 9

Picklist Print

February 24, 2010 8:03:01 AM

Page 10 / 14

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IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3455-1		Manufactured	No				Each	47.0000	2.0000			
Spacer												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	3	
	46138	3	
Main Warehouse	ST58	44	
	55606	4	
	55807	40	

D3455-3		Manufactured	No				Each	41.0000	2.0000			
Spacer												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	41	
	48126	9	
	56047	32	

February 24, 2010 8:03:01 AM

Shop Packet Print

Page 10

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Picklist Print

February 24, 2010 8:03:01 AM

Page 11 / 14

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 IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3462-042		Manufactured	No				Each	4.0000	1.0000			



Bracket Assembly

10-3-225

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	4	
	35860	1	
	55619	3	
Main Warehouse	ST198A	4	

D3463-042



Step Weldment Assembly

Manufactured No

Each 3.0000 1.0000

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	1	
	53512	1	
Main Warehouse	ST494	2	
	55620	2	

N/A

Picklist Print

February 24, 2010 8:03:01 AM

Page 12 / 14

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IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3465-1		Manufactured	No				Each	53.0000	1.0000			
Washer												

10-3-22 SP
W/A

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	53	
	41692	1	
	46134	52	

MS21043-3



Nut

Purchased No

4,252.000 3.0000



10-3-22 SP

Warehouse	Location	Loc Qty	Loc Code
OFFSHORE	FG	80	
	103691	80	
Main Warehouse	ST	4172	
	111819	70	
	112243	29	
	112314	4073	

3

Picklist Print

February 24, 2010 8:03:01 AM

Page 13 / 14

Work Order ID: 56448

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)


Start Date: 24/02/2010

Required Date: 03/03/2010

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV.C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS24665-227		Purchased	No				Each	113.0000	2.0000			
												
COTTER PIN												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	113	
111359	1	
113422	12	
113845	100	

MS24665-227	Purchased	No				Each	113.0000	1.0000				
												
COTTER PIN												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	113	
111359	1	
113422	12	
113845	100	

MS24665-229	Purchased	No				Each	226.0000	2.0000				
												
COTTER PIN												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	226	
111041	226	

February 24, 2010 8:03:01 AM

Shop Packet Print

Page 13

Picklist Print

February 24, 2010 8:03:01 AM

Work Order ID: 56448

Parent Item: D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)


Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verifiedby:DD

Start Date: 24/02/2010

Requi

Start Qty: 1.00

Requ

Component Item ID/ MS24665-302	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route	Unit of Each	Qty on 106.0000	Remaining 1.0000	Qty
										
Cotter Pin										

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	106	
111359	6	
113644	100	

Purchased No

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	44	
103286	17	
103691	27	
Main Warehouse		
ST	232	
109430	232	

NAS1515H5

Washer

February 24, 2010 8:03:01 AM

Shop Packet Print

M114065

14/14

N/A N

45.10/03/18

10-3-22 el

1000 1000 1000

1000



1000 1000 1000

1000 1000 1000

1000 1000 1000

1000 1000 1000

1000 1000 1000

1000 1000 1000

1000 1000 1000

1000

1000

1000 1000 1000

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

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Revision: **M**
Date: 08.12.12

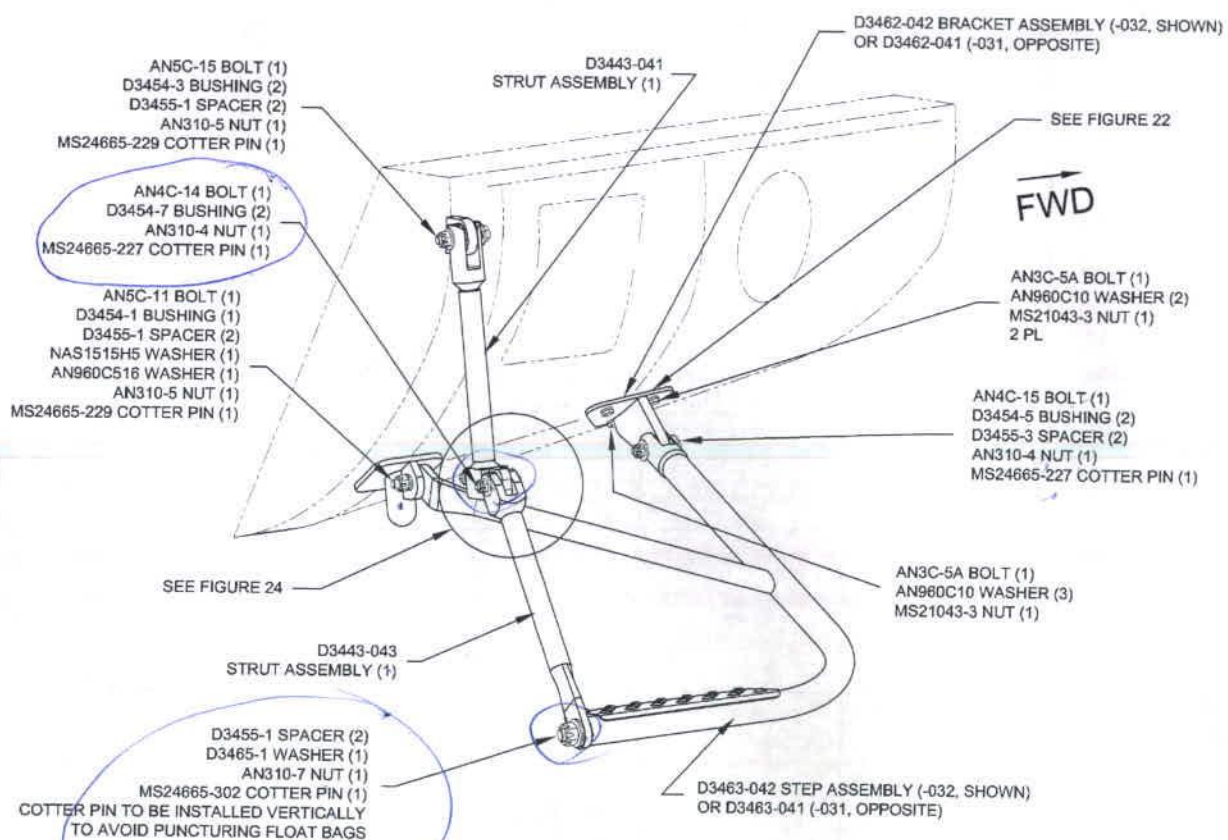


FIGURE 23 - Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

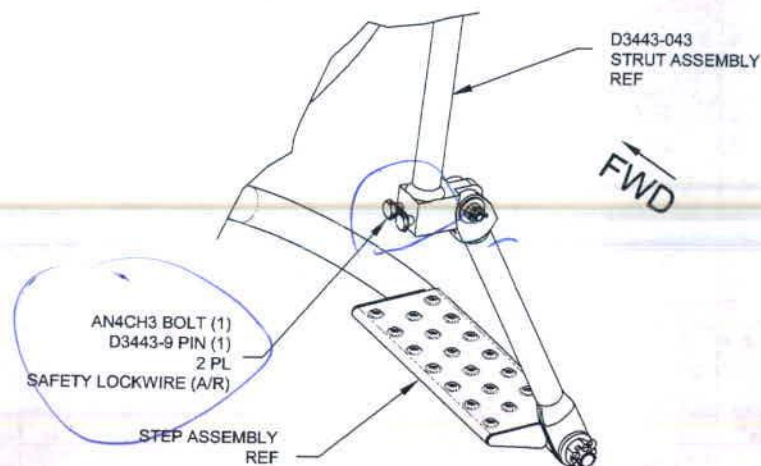


FIGURE 24 - Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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Revision: M
Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER -2
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT -1
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN -1
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries